

Date: Thursday, 23/10/2008 1:32:34 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY LH
Job Number	: 42911		
Estimate Number	: 10266		
P.O. Number	:	Part Number	: D350636013
This Issue	: 23/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2750 REV F
First Issue	: 11	Project Number	: N/A
Previous Run	: 42450	Drawing Revision	: F
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 15/11/2008
Checked & Approved By	: <u>JUD 08-10-23</u>	Qty:	1 Um: Each
Comment	: Est Rev:H 02.09.25 Rearranged procedure steps KJ est rev I 06.03.30 Per rev. D dwg EC Est Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:K 08-09-23 revF as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



for JUD 08.11.14



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 004

20/11/17

2.0

D26003BENT

Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

42940

AT 08-11-06

3.0

D2744

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch

39242

BE 08-11-06

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 6 (D2750-3 details).Drill using drill Jig DT8150 & DT8864 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut

AT 08-11-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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as per dwg D2750.

4-Drill pilot holes for the blade fitting bolt holes using DT8983. Open to 0.500".

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting.

6-Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297"

8-Open up holes of Detail S to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M109213 BE 08-11-06*

12-Grind welds flush as per Dwg D2750

13- scribe batch #.

RT 08-11-06

SL 8-11-7

5.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-11-8

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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9.0	D2739	350 I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

B-43163

AUM 8-11-10



10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B-43013

BE 8-11-11

11.0	D34905	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch:

B-32597

BE 8-11-11

12.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch:

B-41113

BE 8-11-11

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

2- Open holes section AV-AV 0.3125" (4 per side)

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

exp. date:

B-109149
8-10-30

528-11-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 10)

A/R Aluminum Rod batch: *m109813 BB 08-11-11*

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

*AWM
8-11-11*

14.0 QC10

VISUAL INSPECTION OF GROUND WELDS



08-11-12 (D)

Comment: VISUAL INSPECTION OF GROUND WELDS

15.0 QC5

INSPECT WORK TO CURRENT STEP



08-11-12 (D)

Comment: INSPECT WORK TO CURRENT STEP

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(D)

Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FX 08/11/13

17.0

POWDER COATING

POWDER COATING



(X)

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

m-l 08/11/13

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-11-13

(X)

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: *M100621*

JP

08-11-13

(X)

W/O:		WORK ORDER CHANGES					
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Job Number: 42911

Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
1-Install inserts as per dwg D2750

JD 08-11-13 (K)

21.0 D2745 Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing
Batch: B40726 JD

22.0 D37911 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: B42982 JD

23.0 D37931 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe
Batch: B42479 JD

24.0 D37933 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe
Batch: B42927 JD

25.0 D37941 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket
Batch: B42480 JD

26.0 D37943 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket
Batch: B43116 JD 08-11-13 (K)

W/O:		WORK ORDER CHANGES					
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Job Number: 42911

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	D353525	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1342926

HL

28.0	D353625	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342234

HL

29.0	D35371	Wearpad
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: 13412820

HL

30.0	D36311	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: 1341141

HL

31.0	D3488041	Blade Fitting Assembly, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: 1336234

HL

32.0	NAS1611010	O-RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

NAS1611-010 batch: 11100

(or MS28775-010) batch: 11100539

XHL

33.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1342936

HL

08-11-13

(XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42911

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	D3492045	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B42478

MS

35.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)

Bolt

Batch: M1109545

JH

36.0	AN3C6A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M108880

JH

37.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M109765

JH

38.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: M106896

JH

39.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

washer

Batch: M1209752

JH

40.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WASHER

Batch: M109632

JH

08. 11. 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 42911

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M1104249

JD

42.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M1109740

JD

43.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: M1104291

JD

44.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: M1104291

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

✓ SIKAFLEX 241

BATCH: M1109449

EXP DATE: 08/11

✓ 4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M1101223

✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: M1104251

JD 08.11.13

45.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

JD 08.11.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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46.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

47.0	D2741	Blade, 350 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade
Batch: 42222

48.0	AN960C816L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M109632

49.0	MS21083C8	NUT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: M109840

50.0	AN8C21A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: 109772

51.0	NAS1515H8L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: M108964

52.0	D34931	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: 40829

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/11/17 (X)

54.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

Rev C

SS 08/11/17 (X)

55.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/18 (X)

Job Completion



MF 08-11-17

B42911

W/O:		WORK ORDER CHANGES					
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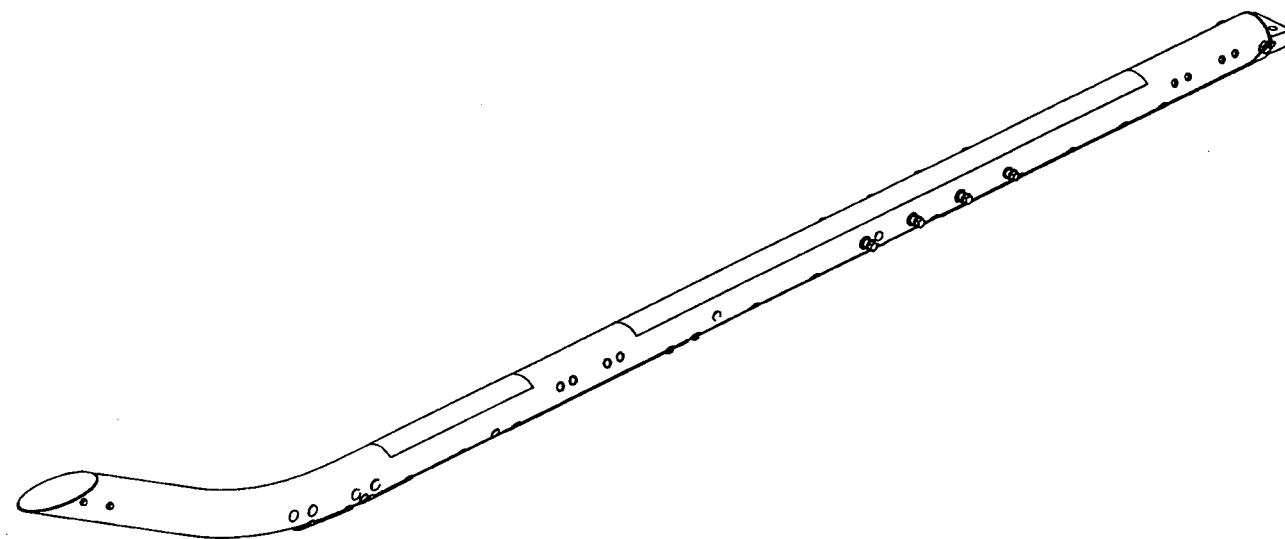
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

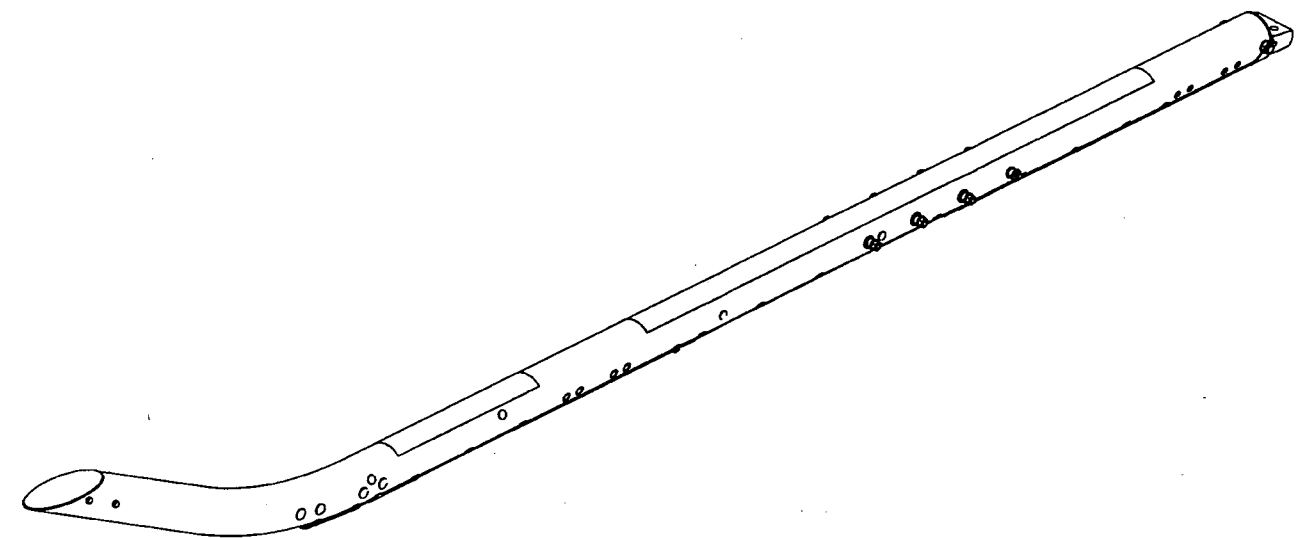
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16 SHORT COPY RETURN TO ENGINEERING UNCONTROLLED COPY
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 42911
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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D

D

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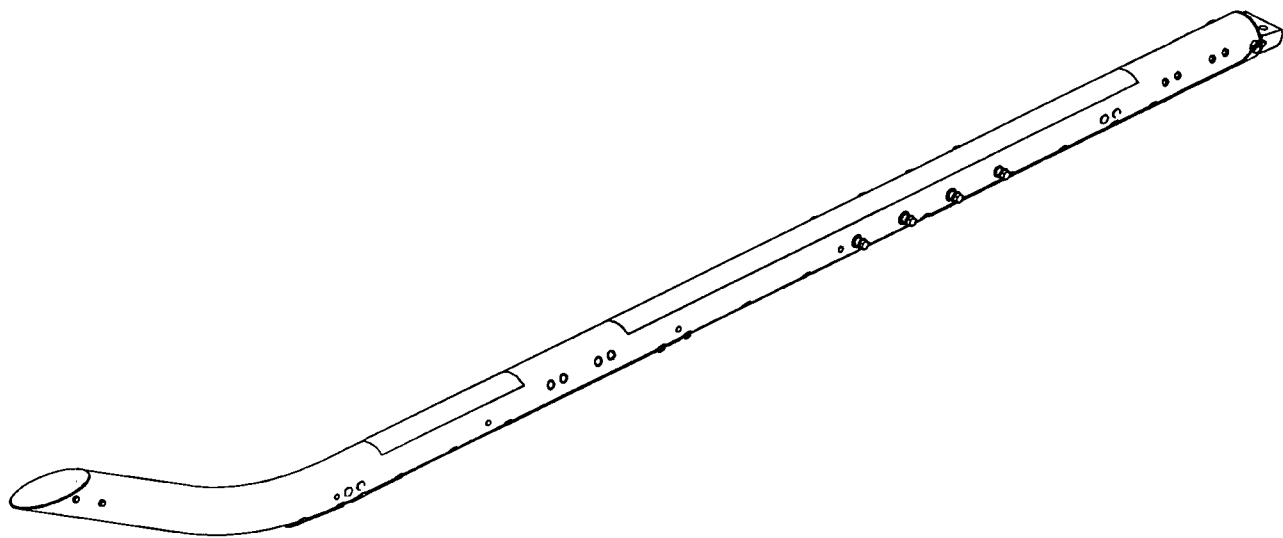
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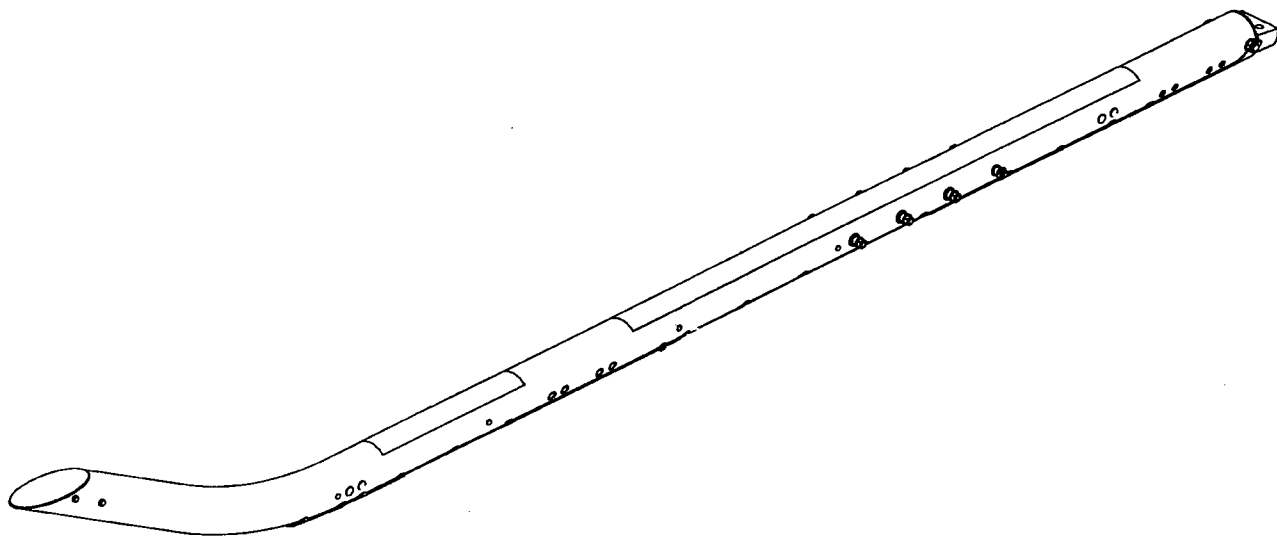
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A

A



D2750-043 350 SKIDTUBE ASSEMBLY, LH

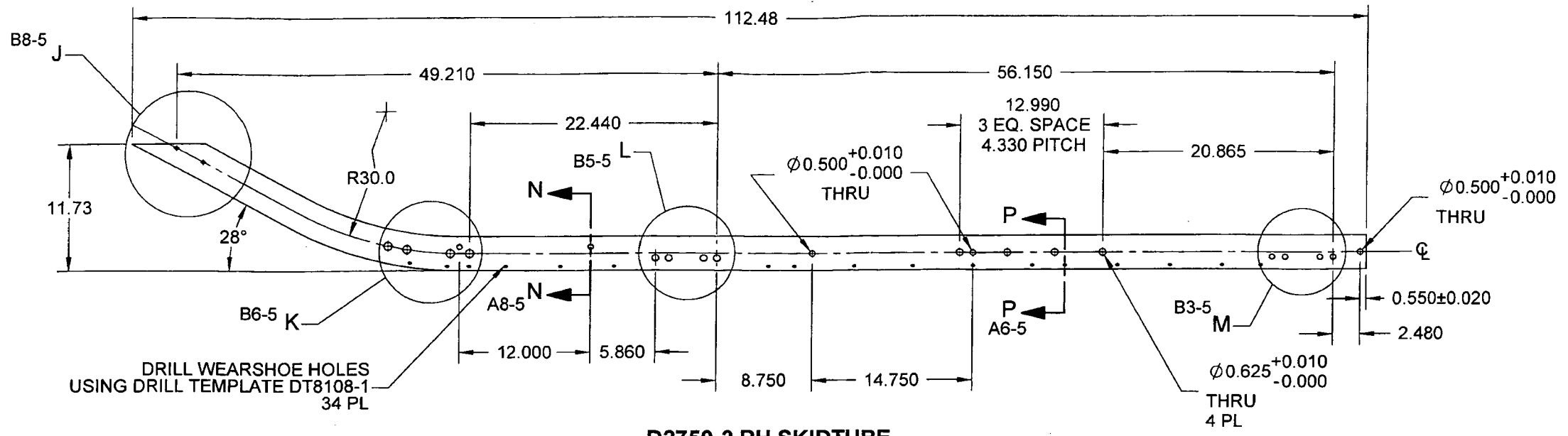


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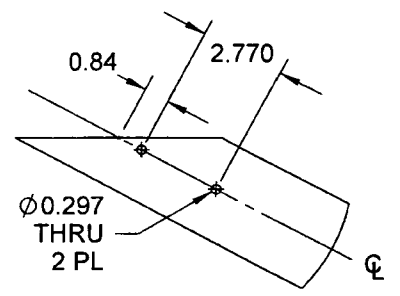
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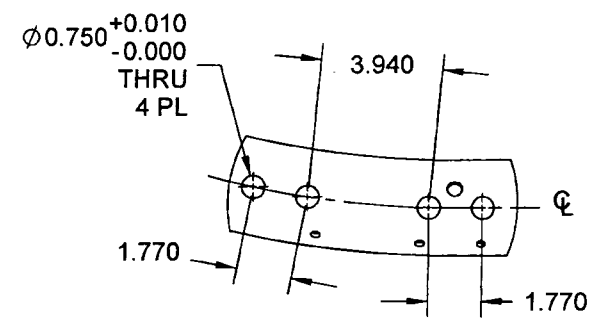
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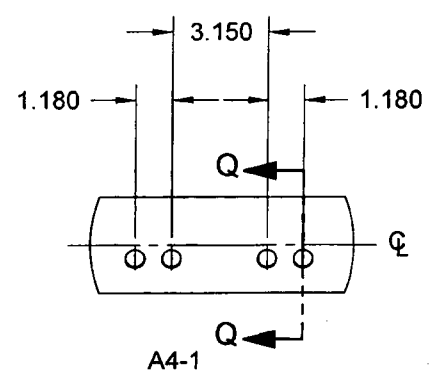
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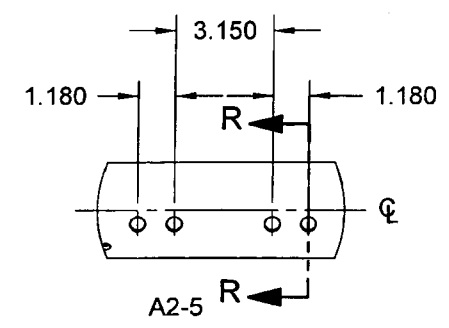
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SCALE 2X
D8-5



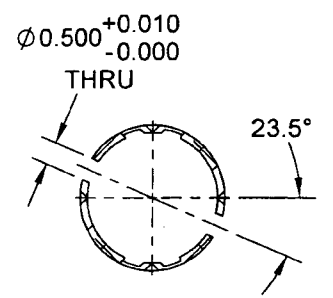
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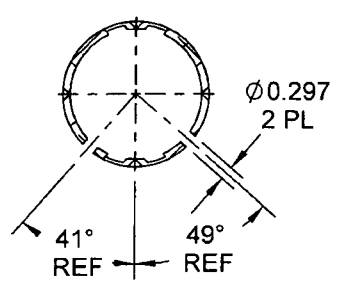
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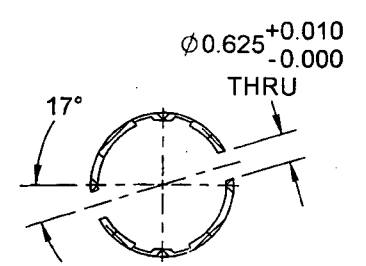
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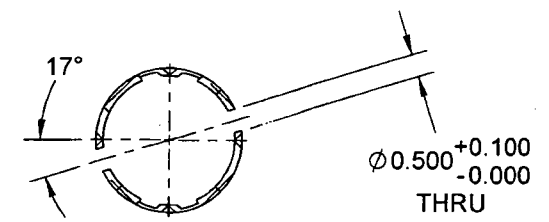
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SCALE 3X, 2 PL
C6-5



SECTION P-P
SCALE 3X, 17 PL
C4-5



SECTION Q-Q
SCALE 3X, 4 PL
B5-5

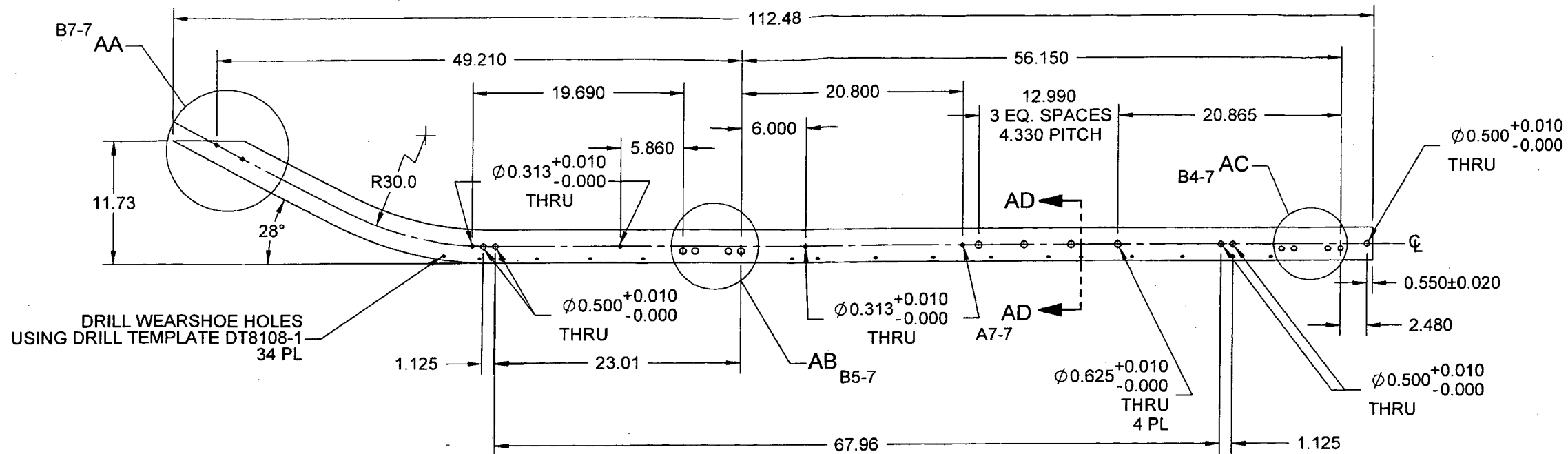


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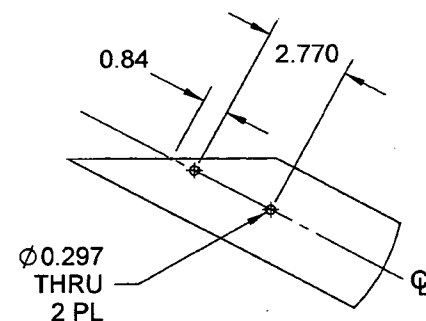
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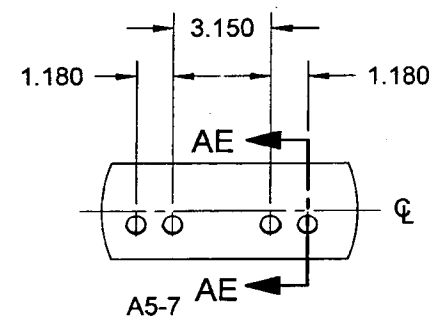
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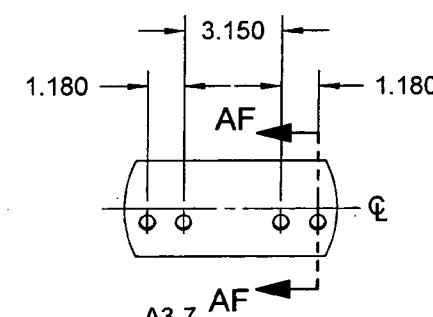
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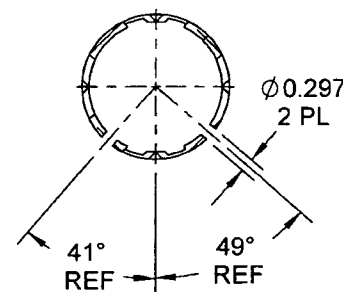
DETAIL AA
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SCALE 2X



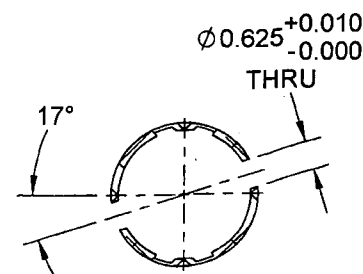
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SCALE 2X



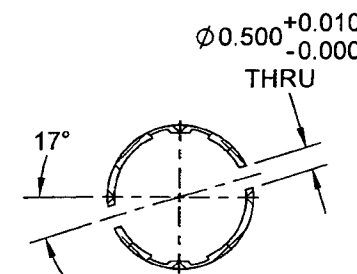
DETAIL AC
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SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL



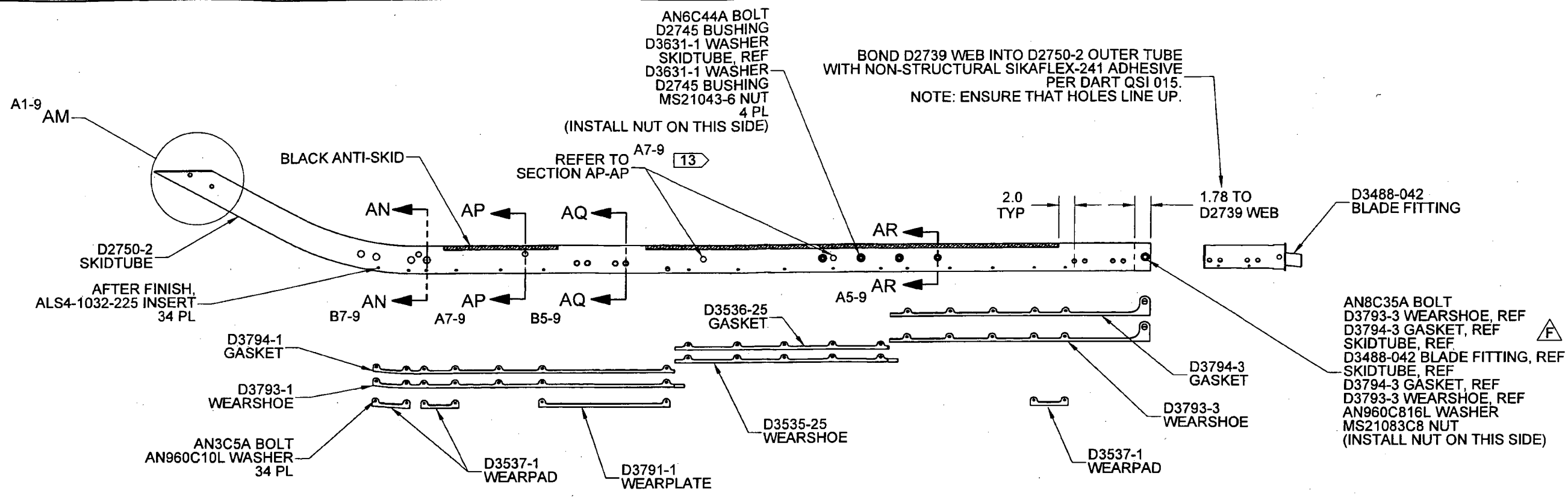
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SCALE 3X, 4 PL

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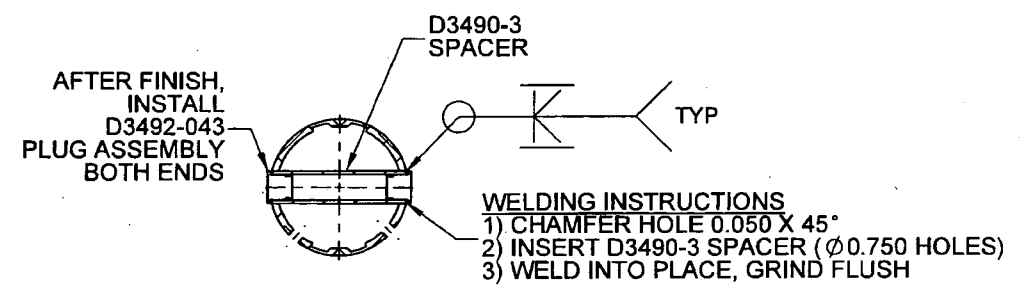
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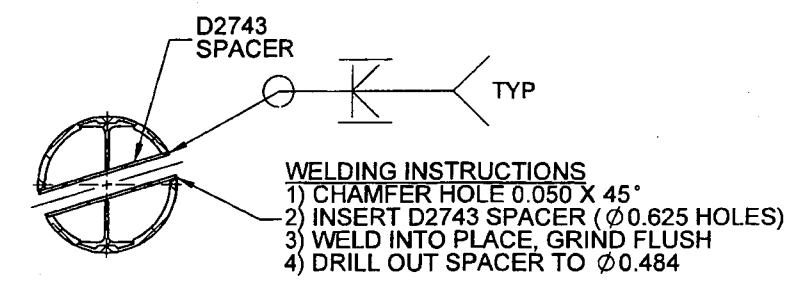
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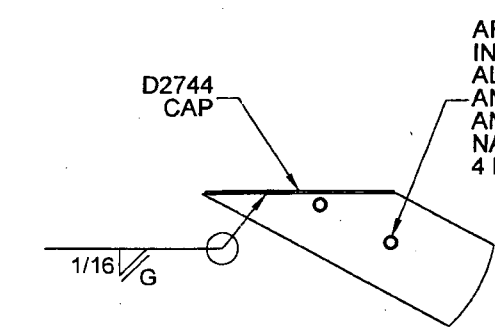
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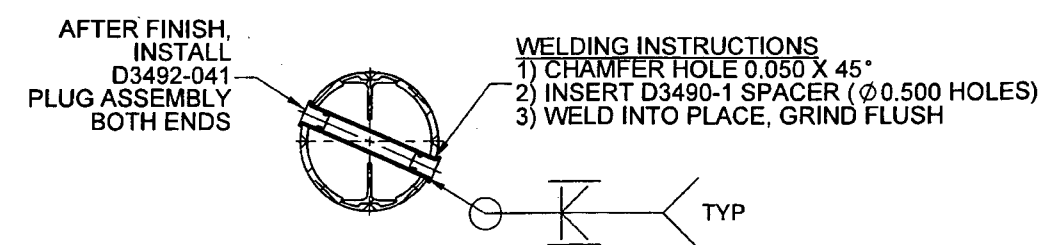
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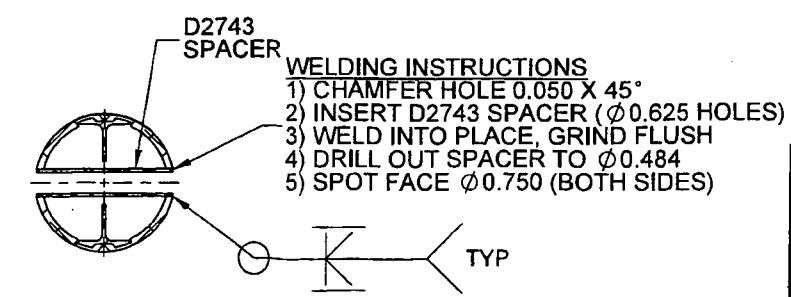
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
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(HARDWARE REMOVED FOR CLARITY)

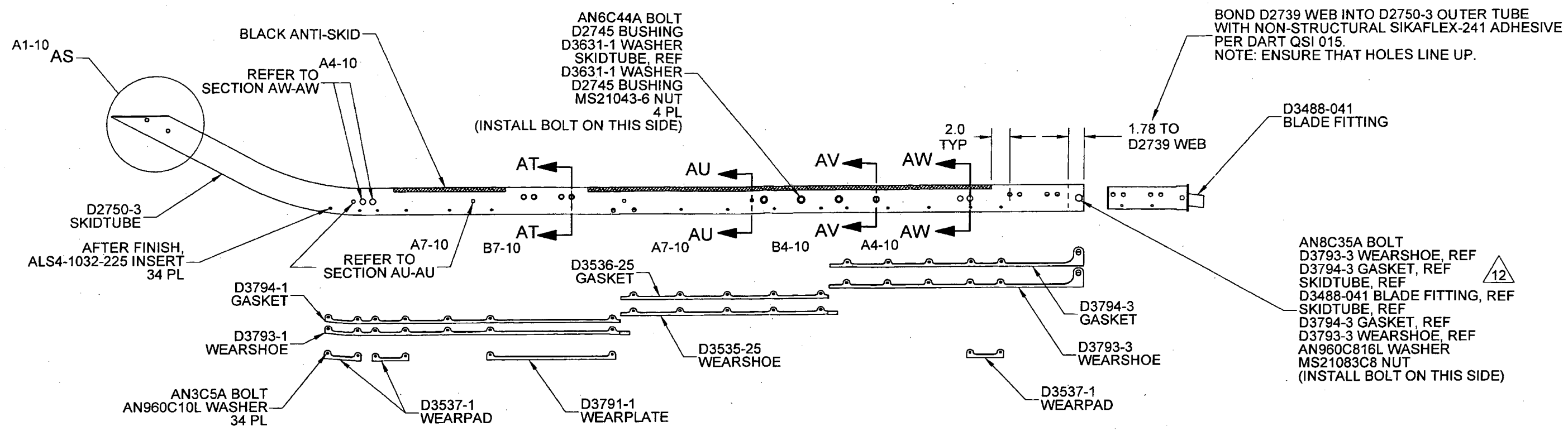
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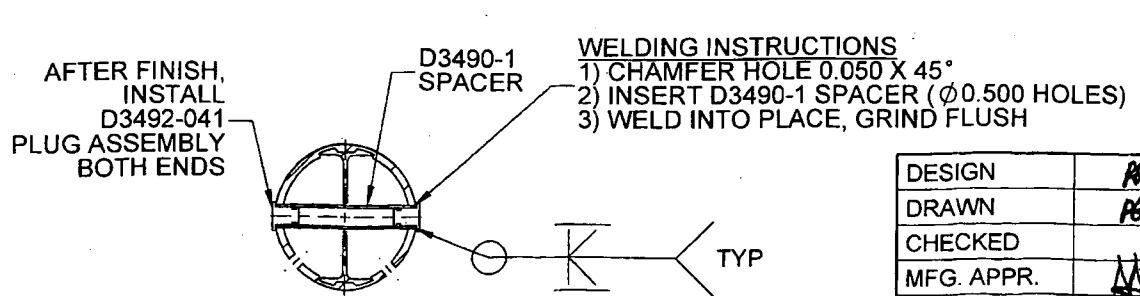
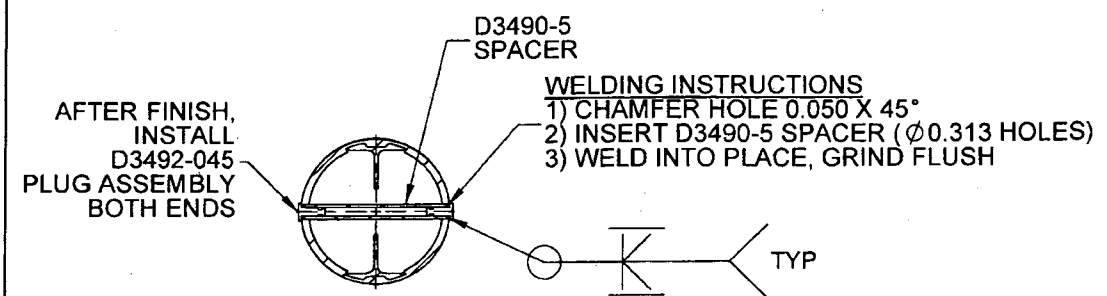
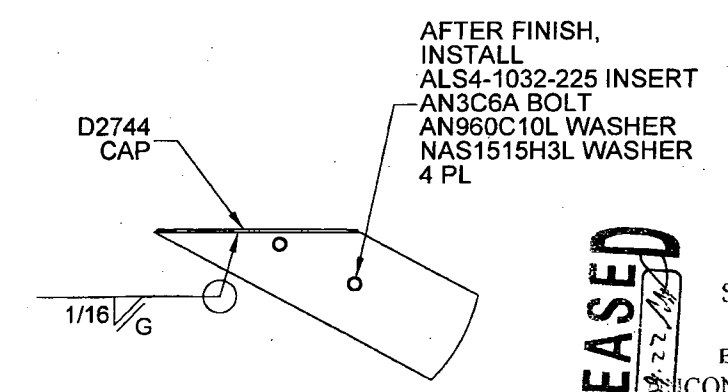
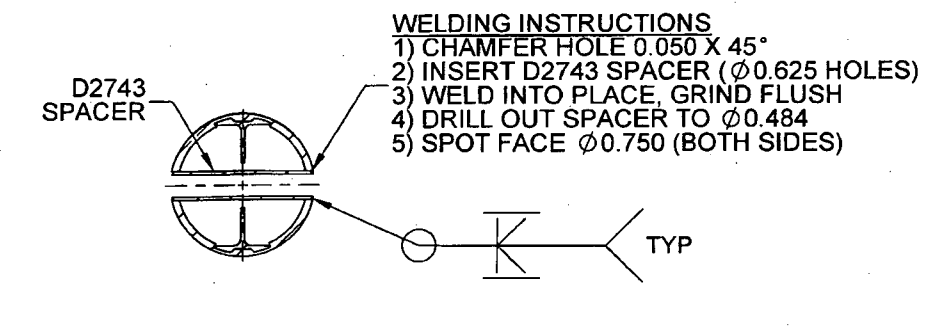
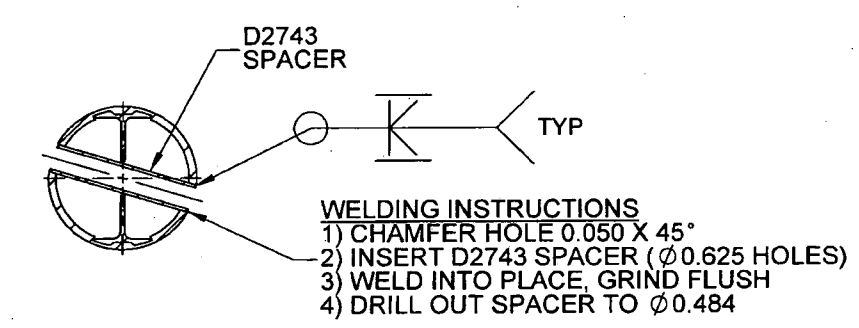
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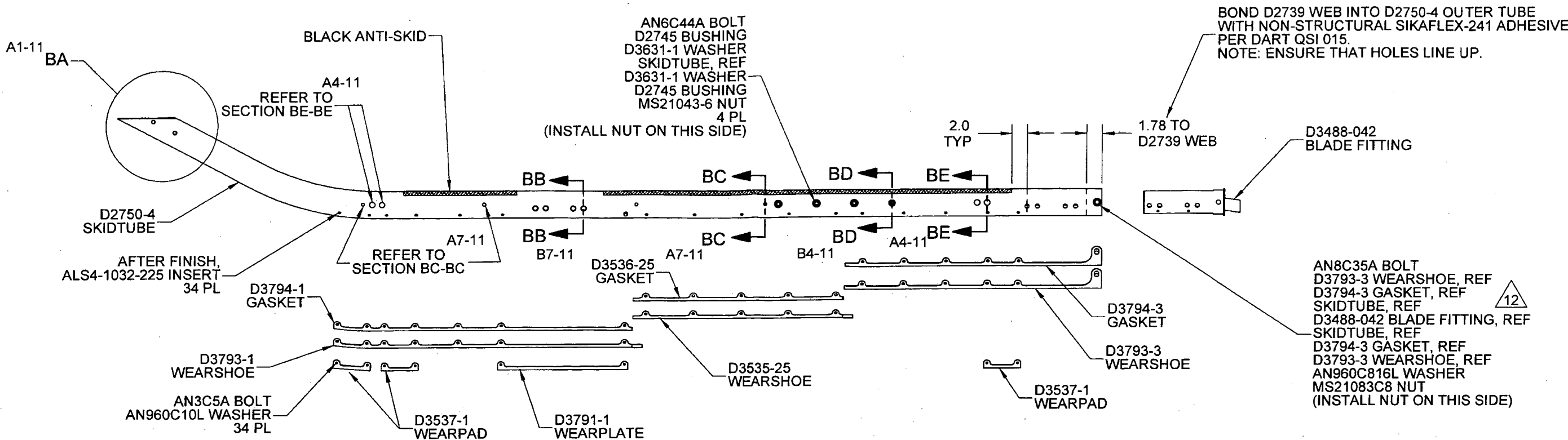


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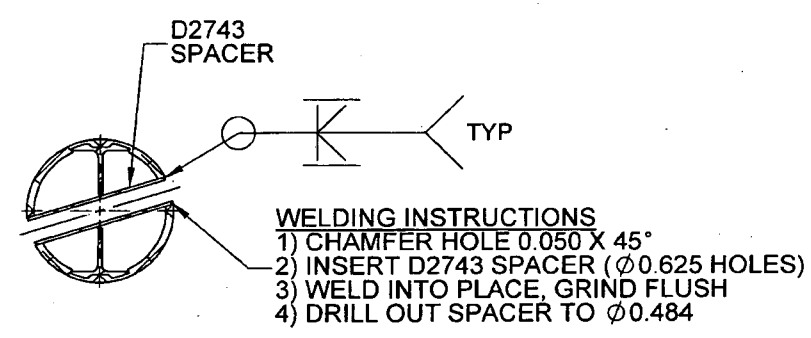
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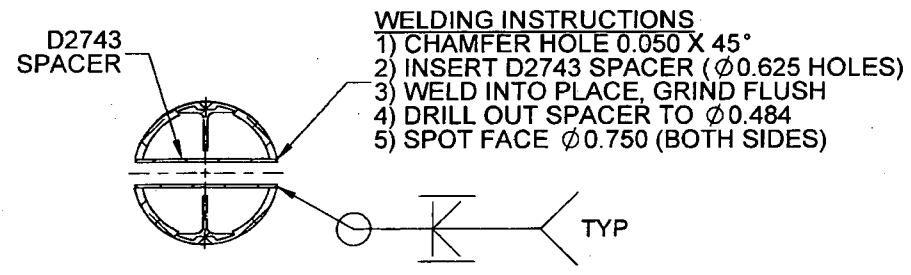


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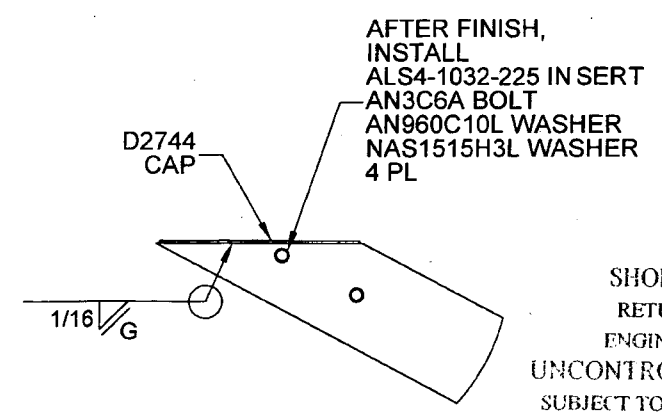
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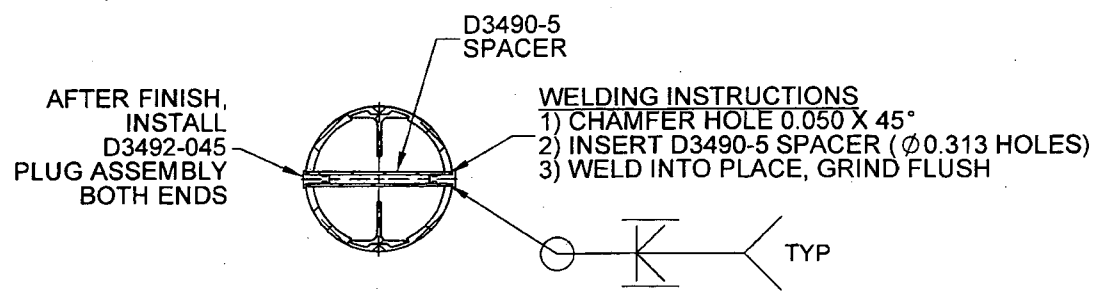
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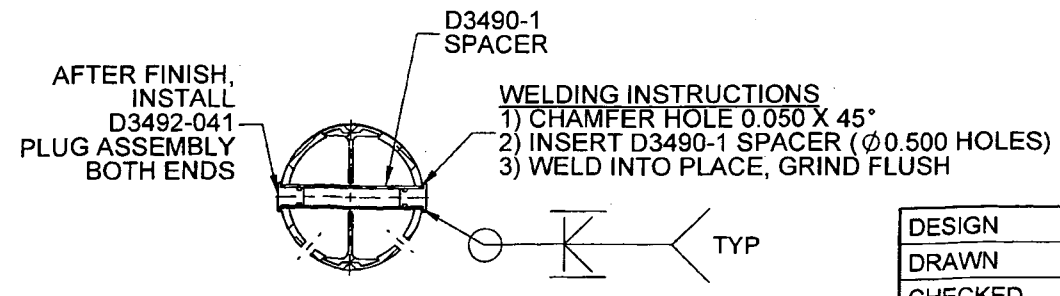
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DETAIL BA
SCALE 2X



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

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